



Date: Wednesday, 5/23/2007 3:43:28 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE, OUTBOARD, LH, 206			
Job Number	: 32505					
Estimate Number	: 10818					
P.O. Number	: N/A	Part Number	: D26651			
This Issue	: 5/23/2007	S.O. No.	N/A	Drawing Number	: D2665 REV.D	
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: N/A	Type	MACHINED PARTS	Drawing Revision	: D	
Previous Run	: 29748			Material	: N/A	
Written By				Due Date	: 6/10/2007	
Checked & Approved By				Qty:	12	Um: Each
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC Est Rev:D As per Rev D 07-03-19 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101003	7075-T7351 2X6.25X7.875	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) → 24 blanks taken in inventory? 7075-T7351 2X6.25X7.875 Cut Size 2.0" x 6.25" x 7.88" Grain Along Long 7.88 Length Batch no <u>33792</u>	0 blanks allocated?
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program batch number. 1-Inspect part number and batch number are programmed correctly. 3-Fixturing Inspection last completed on <u>N/A</u> by <u>N/A</u> 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet 6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet 7- Debur	<u>SC</u> 07-04-12 (12)
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	<u>SC</u> 07-04-12 (12)
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>SC</u> 07-04-12 (12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/09/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:43:28 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, LH, 206

Job Number: 32505

Part Number: D26651

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

07/09/12

(12)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m. h / BK 07/09/13

7.0 POWDER COATING POWDER COATING



M105086

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

HJ

07-09-13

(12)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



7/9/13 50

(12X)

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



7/9/13 50

(12X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0 QC21 FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

07/09/14

Job Completion



U 8/9/14

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	32505
Description: 206 Saddle, Outboard, Left side				Part Number:	D2665-1
Inspection Dwg: D2665 Rev. D				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.125	.124	.124	.124		
B	0.100	0.140		.130	.130	.130	.132		
C	1.125	1.145		1.135	1.135	1.137	1.137		
D	0.615	0.685		.665	.665	.665	.665		
E	0.240	0.260		.255	.255	.255	.255		
F	1.313	1.343		1.327	1.327	1.327	1.327		
G	0.210	0.230		.221	.221	.221	.221		
H	0.100	0.180		.137	.137	.137	.137		
I	2.470	2.510		2.496	2.496	2.496	2.496		
J	1.565	1.585		1.568	1.568	1.568	1.568		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.110	.118	.118	.118		
M	0.990	1.010		1.008	1.005	1.005	1.005		
N	0.510	0.515		.510	.510	.510	.510		
O	5.990	6.010		6.001	6.001	6.001	6.001		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.315	0.322		.319	.319	.319	.319		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.802	.801	.801	.801		
W	0.540	0.560		.550	.551	.551	.551		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.259	.259	.259	.259		
Z	0.912	0.932		.923	.920	.920	.920		
AA	0.490	0.510		.503	.503	.503	.503		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									

Accept/Reject

Measured by:	SG	Audited by:	Shd
Date:	07.09.06	Date:	07/09/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	Shd

DART AEROSPACE LTD				Work Order:	32505
Description: 206 Saddle, Outboard, Left side				Part Number:	D2665-1
Inspection Dwg: D2665 Rev. D				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	26	27	28		
A	0.100	0.140		.125	.125	.120	.120		
B	0.100	0.140		.120	.130	.126	.126		
C	1.125	1.145		1.135	1.135	1.135	1.135		
D	0.615	0.685		.665	.665	.665	.665		
E	0.240	0.260		.255	.255	.255	.255		
F	1.313	1.343		1.327	1.327	1.327	1.327		
G	0.210	0.230		.224	.224	.224	.224		
H	0.100	0.180		.137	.137	.137	.137		
I	2.470	2.510		2.496	2.496	2.496	2.496		
J	1.565	1.585		1.568	1.568	1.568	1.568		
K	0.235	0.240		.239	.239	.239	.239		
L	0.100	0.120		.110	.110	.110	.110		
M	0.990	1.010		1.006	1.006	1.006	1.006		
N	0.510	0.515		.510	.510	.510	.510		
O	5.990	6.010		6.003	6.003	6.003	6.003		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.315	0.322		.314	.319	.319	.319		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.801	.801	.801	.801		
W	0.540	0.560		.551	.551	.551	.551		
X	1.674	1.684		.674	.674	.674	.674		
Y	0.257	0.262		.259	.259	.259	.259		
Z	0.912	0.932		.920	.920	.920	.920		
AA	0.490	0.510		.505	.503	.503	.503		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	SG	Audited by:	✓
Date:	07.09.12	Date:	07/09/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM ✓	✓

DART AEROSPACE LTD	Work Order:	32505
Description: 206 Saddle, Outboard, Left side	Part Number:	D2665-1
Inspection Dwg: D2665 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.122	.122	.122	.122		
B	0.100	0.140		.127	.127	.127	.127		
C	1.125	1.145		1.135	1.135	1.135	1.135		
D	0.615	0.685		.660	.660	.660	.660		
E	0.240	0.260		.252	.257	.257	.257		
F	1.313	1.343		1.325	1.325	1.325	1.325		
G	0.210	0.230		.221	.221	.221	.221		
H	0.100	0.180		.140	.140	.140	.140		
I	2.470	2.510		2.495	2.495	2.495	2.495		
J	1.565	1.585		1.575	1.575	1.575	1.575		
K	0.235	0.240		.234	.234	.234	.234		
L	0.100	0.120		.110	.110	.110	.110		
M	0.990	1.010		1.006	1.006	1.006	1.006		
N	0.510	0.515		.510	.510	.510	.510		
O	5.990	6.010		6.003	6.003	6.003	6.003		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.315	0.322		.319	.319	.319	.319		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.363	1.363		
V	0.787	0.807		.800	.800	.800	.800		
W	0.540	0.560		.550	.550	.550	.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.921	.921	.921	.921		
AA	0.490	0.510							
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									

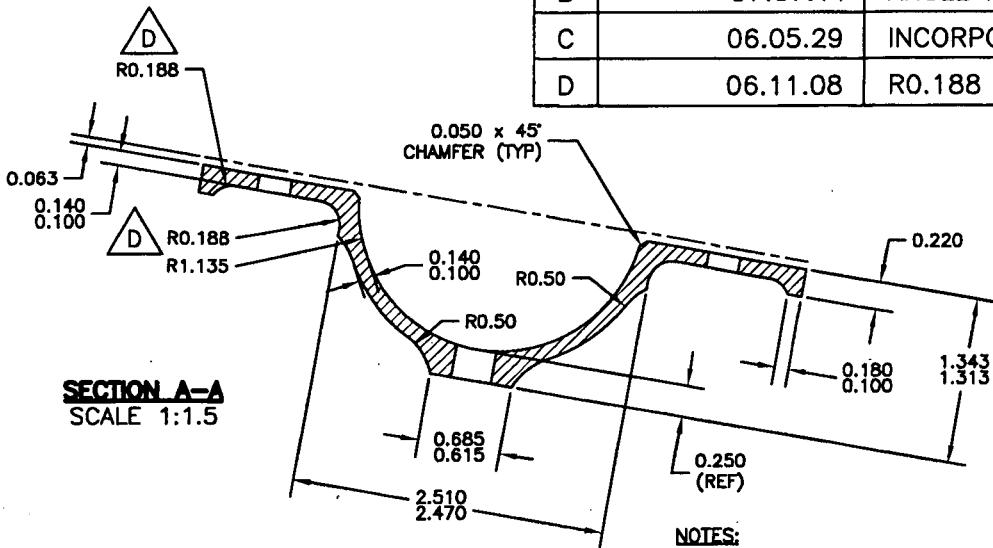
Accept/Reject

Measured by:	<i>SG</i>	Audited by:	<i>JML</i>
Date:	07.09.06	Date:	07.09.12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM <i>JK</i>	<i>JLM</i>

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2665 REV. D
PH	CH	SHEET 1 OF 1
DATE		SCALE
06.11.08		1:3
A	97.03.25	NEW ISSUE
B	97.07.11	ANGLE AND NOTES ADDED
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313



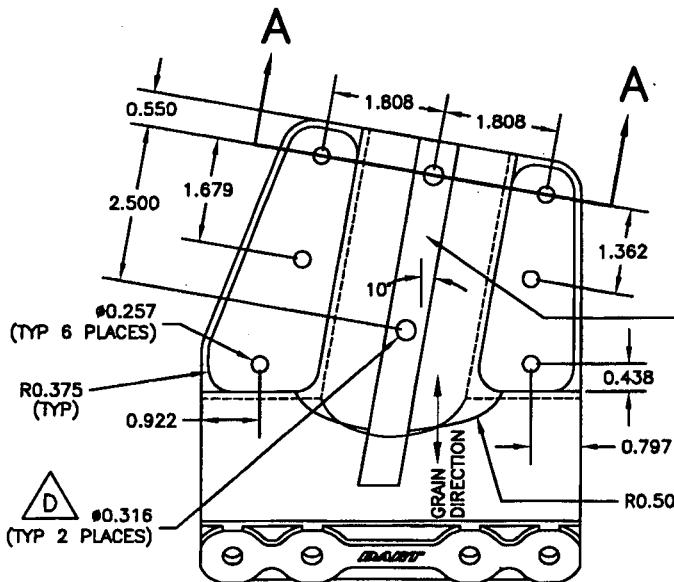
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07.02.12

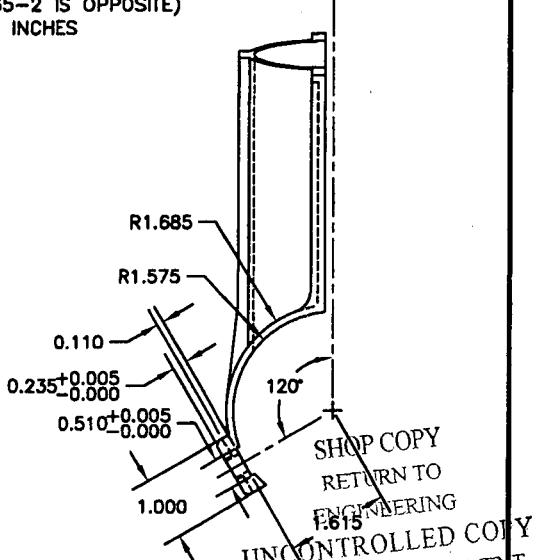
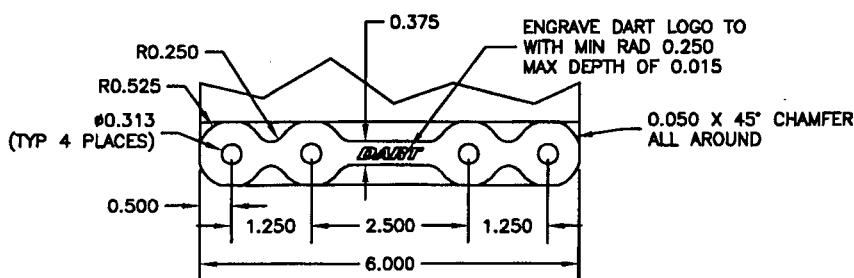
SECTION A-A
SCALE 1:1.5

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART NUMBER AND BATCH NUMBER TO MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010



UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 32505

D2665-1 SADDLE FWD OUTSIDE HIGH

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